

Work Order ID 152668

Thursday, November 03, 2016 3:09:00 PM

152668

Page 1

Item ID: D3174-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Lug
Start Date: 11/4/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 11/11/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: sm Date: 16/11/3 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3174	Rev A1 <u>BLP</u>								PR 16/11/08
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.08							
FLOW CNC Waterjet	1-Cut as per Dwg D3174 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2- Debur if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.02							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.03							
Quality Control									

DAS
38
9-89
NOV 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo <i>N/A</i> <i>DAS 38 9-89</i>	0.00 0.03							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo <i>*****STOCK IN BASKET CELL*****</i> <i>LOCATION : WA004</i>	0.00 0.02							<i>10/11/10</i> <i>DAS 6 9-89</i> NOV 8 7 2016
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.17							<i>16/11/10</i> <i>2m 16/11/9</i>

DQA: _____ Date: _____



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Picklist Print

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152668

Parent Item: D3174-1

D3174-1

Parent Item Name: Mounting Lug

Start Date: 11/4/2016

Required Date: 11/11/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: A03.01.29New issueKJ/RF
IPP Rev:B 08-08-19 now made on water jet DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	7.0950	0.0408	0.429474			

M304S16GA

304/316 Sheet .063

PR 16/11/16

M 304 12 GA

Location

Loc Qty

Loc Code

MAT010

7.095

m135377

0.545

m135559

0.85

m135689

5.7

0.45

16.11.08

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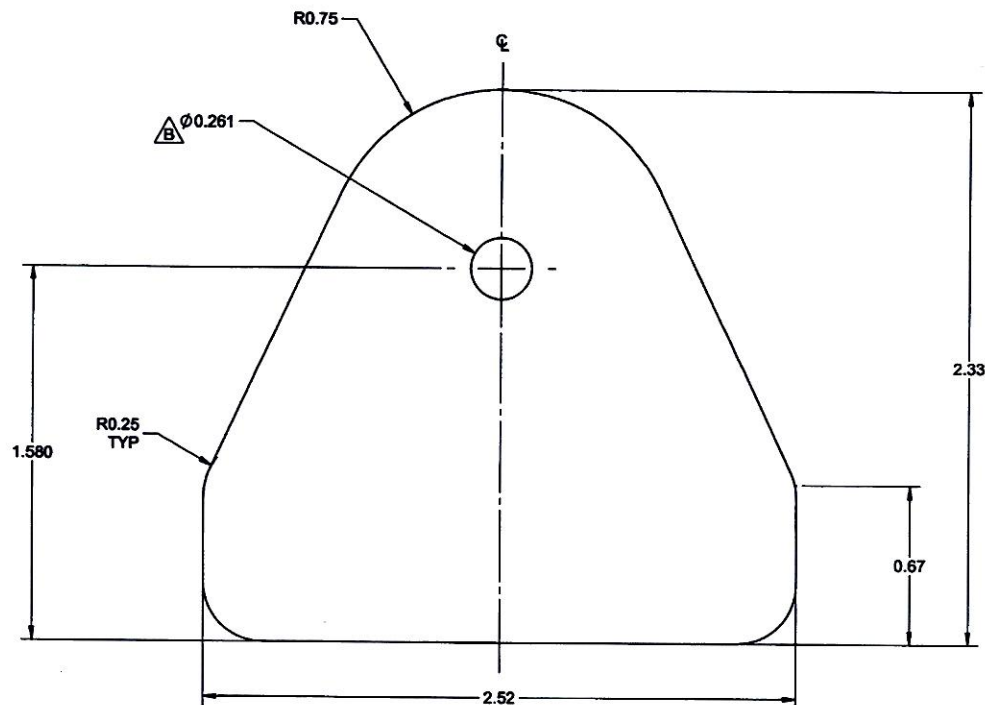


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D3174-1 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152668
Em 16/11/3

RELEASED

2016 NOV 02
 EON 16-93 97

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 12 GAUGE 
 PER MIL-S-5059
 OR AMS 5513 (304)
 OR AMS 5524 (316)
 OR ASTM A240
 OR ASME SA240
 REF DART SPEC M304S12GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.14 lbs

B	REFORMAT DRAWING, REVISE SHEET THICKNESS (ZN B2-1, A7-1); Ø0.261 WAS Ø0.257	VS	15.11.09
A	NEW ISSUE	CP	02.12.03
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	DD	D3174	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	MOUNTING LUG	NTS
DATE	15.11.09	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
WORK ORDER WITHOUT NOTICE SUBJECT TO AMENDMENT UNCONTROLLED COPY ENGINEERING RETURN TO CONTROL COPY									
Root Cause		FAULT CATEGORY							
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Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								